



HELICOPTERS, INC.

GULF COAST DIVISION
LAKE CHARLES, LOUISIANA

PROCESS SPECIFICATION

PROCESS SPECIFICATION NUMBER: ERA-1013

412 Auxiliary Fuel Tanks

INSTALLATION OF NUT INSERTS AND STAINLESS STEEL BUSHINGS

PREPARED BY:

John E. Stanley
John E. Stanley
MESH PLASTICS LTD.

DATE: 1/27/87

APPROVALS

MANUFACTURING	QUALITY CONTROL	ENGINEERING	
<i>Harold R. Dickerson</i>	<i>John E. Stanley</i>	<i>John E. Stanley</i>	MESH
<i>L. F. Lanner</i>	<i>David K. Murphy</i>	<i>David K. Murphy</i>	ERA

PROCESS SPECIFICATION

Scope: This specification outlines the requirements for installing nut inserts and stainless steel bushings in the 412 Auxiliary Fuel Tanks.

Conformation: This specification does not conform to any existing government specification.

Subcontractors: MESH PLASTICS, LTD. of Lake Charles, Louisiana, or its subcontractor shall be the only subcontractors qualified to construct the FRP requirements and shall comply with this process specification. Any deviations or variations are to be submitted to ERA for approval with proper documentation prior to fabrication.

Conflicts: In the event of a conflict with engineering drawing(s) and this specification, the drawing(s) shall govern.

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Installation of Nut Inserts and Stainless Steel Bushings in the 412 Auxiliary Fuel Tanks

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Rev	Date	Pages	Approvals				Engineering	
			Manufacturing		Quality Control		MESH	ERA
			MESH	ERA	MESH	ERA		
IR	1/27/87	ALL	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

MATERIALS

<u>MATERIAL</u>	<u>NAME</u>	<u>MANUFACTURER</u>
Resin	Derakane 8084	Dow Chemical Midland, MI
Promoter	Cobalt Napthenate	AKZO Chemie New Brunswick, NJ
Accelerator	Dimethylaniline	Buffalo Colors West Paterson, NJ
MEKP Catalyst	Hi Point 90	Witco Chemical Richmond, CA
	Lupersol DHD 9	Lucidol Chemical Buffalo, NY
Mold Release	PVA	Rexco Carpenteria, CA
	Cerea Mold Release Wax	Ceara Products, Inc. Denver, CO
UV Inhibitor	UV-9	Industrial Chemicals Atlanta, GA

DATE 6/26/95	ENGINEERING ORDER		E.O. No. A-1	SHT. 1 OF 1
BY T. Harville	TITLE PROCESS SPECIFICATION		DWG. AFFECTED 1013	
APPROVED BY 			ENTERED ON COMPUTER BY: DATE:	
REASON FOR CHANGE: ADD ALT P/N FOR 3/4 & 1 1/2 oz TYPE "E" GLASS MAT (M127)				
<p>3/4 oz TYPE "E" GLASS MAT. M113-3/4 oz CERTAINTeed OR M127-3/4 oz CERTAINTeed WICHITA FALLS, TX.</p> <p>1 1/2 oz TYPE "E" GLASS MAT. M113-1 1/2 oz CERTAINTeed OR M127-1 1/2 oz CERTAINTeed WICHITA FALLS, TX.</p>				

MATERIALS

<u>MATERIAL</u>	<u>NAME</u>	<u>MANUFACTURER</u>
Putty filler (Amorphous Fumed Silica)	Aerosil	Dequssa Corp. Teterboro, NJ
	Cabosil	Cabot Corp. Boston, MA
Milled Fibers	731 ED	Owens-Corning Anderson, S.C.
3/4 oz Type 'E' glass mat	M113 - 3/4 oz.	Certainteed Wichita Falls, TX
10 mil 'C' glass, or	Modiglass	Reichold Chemical Bremen, OH
	Manville Glass	Manville Corp. Denver, CO
10 mil 'A' glass veil	Surglass	Superior Glass Bremen, OH

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MATERIALS

<u>MATERIAL</u>	<u>NAME</u>	<u>MANUFACTURER</u>
Paraffinated Styrene	TF-100	Industrial Chemicals Atlanta, GA
Grinding Discs	36 Grit Type D 60 Grit Type C 80 Grit Type C	3M Corp. St. Paul, MN
Mold surface	Black Tooling Gel	Glidden
Wet/Dry Sandpaper	100 Grit 320 Grit 400 Grit 600 Grit	3 M Corp. St. Paul, Minn.

INSTALLATION

- 1) Lightly sandblast area of part(s) to be bonded.
- 2) Apply one hot coat of Derakane 8084 resin containing UV inhibitor (no pigment) to sandblasted area. Allow to dry.
- 3) Sand area on part where insert or bushing will be bonded using 40 grit sandpaper, approximately 1-1/2" around predrilled holes.
- 4) Apply second hot coat of Derakane 8084 resin containing UV inhibitor (no pigment) over previously coated area and area sanded in step 3.
- 5) While resin is still wet, position part in predrilled holes. Allow to cure until resin hardens.

NOTE: STEPS 6 THROUGH 10 APPLY TO NUT INSERTS ONLY.

- 6) Apply one layer of 3/4 oz. type E glass mat over insert, extending approximately 1" on either side. Saturate with Derakane 470-36 resin containing UV inhibitor (no pigment). Deaerate with serrated rollers.
- 7) Apply second layer of 3/4 oz. type E glass mat over insert, extending approximately 1" on either side. Saturate with Derakane 470-36 resin containing UV inhibitor (no pigment). Deaerate with serrated rollers.
- 8) Apply third layer of 3/4 oz. type E glass mat over insert, extending approximately 1" on either side. Saturate with Derakane 470-36 resin containing UV inhibitor (no pigment). Deaerate with serrated rollers.
- 9) Apply one layer 10 mil C-veil over the wet mat surface, making sure that all mat fibers are covered. Saturate with Derakane 470-36 resin containing UV inhibitor (no pigment). Deaerate with serrated rollers.
- 10) Allow laminate to exotherm and cool down. Dress down any rough areas.

INSPECTION

It is the purpose of the inspection to verify that each part has been fabricated in accordance with and meets the requirements of this specification.

RESPONSIBILITIES: It is the responsibility of the fabricator to make available to ERA Helicopter or his authorized representative any or all of the following:

Records: Records pertaining to the part(s) being purchased shall be supplied when requested. These may include:

- Materials specifications
- Equipment drawings or mold jig
- Materials test results.
- Dimensional verification reports.
- Rework and repair reports.

MATERIALS:

Raw materials used for laminates shall be virgin materials and shall be free of contaminants as described on Pgs. 10 and 11.

FABRICATED PARTS: The part to be inspected shall be properly located and positioned, and shall be in condition to permit safe and thorough inspection. Reasonable means shall be provided to permit the inspector to visually examine the entire inner and outer surfaces of the part.

Allowable defects are as shown on Pgs. 8 and 9.

The following inspection tools and equipment should be made available for use by the inspector.

- Barcol hardness tester.
- Acetone squeeze bottle with acetone.
- Extension cord with ground fault switch.
- A vapor tight inspection light.
- Thickness gauge.

INSPECTION

TEST OF FINISHED
PARTS:

The following basic tests shall be included as a minimum in the Acceptance Inspection.

Barcol Hardness Test - A test of resin cure should be made in accordance with ASTM D2583. Take 10 readings, discard highest and lowest, average the remaining readings. Minimum acceptable average reading is 30.

Surface Cure Test - An acetone test should be used to detect surface inhibition on surfaces exposed to air during cure. The procedure that should be used is the following: rub a few drops of acetone on the surface and check for tackiness after the acetone has evaporated. Persistent tackiness indicates incomplete cure.

Dimensions - The inspector should be provided with copies of all approved drawings or mold jigs.

OTHER APPLICABLE DOCUMENTS:

ASTM Standards

C 581-74-Test Method for Chemical Resistance of Thermosetting Resins Used in Glass Fiber Reinforced Structures.

D 638-77a-Test method for Tensile Properties of Plastics.

D 790-71-Test Methods for Flexural Properties of Plastics and Electrical Insulating Materials.

D 883-78a-Definitions of Terms Relating to Plastics.

D 2583-75-Test Method for Indentation Hardness of Rigid Plastics by Means of a Barcol Impressor.

ALLOWABLE DEFECTS

Defect	Surface inspected
Cracks(Through part)	None
Crazing (fine surface cracks)	Max dimension 1/2 in., max density 5 per sq. ft. min 2 in apart
Blisters(rounded elevations of the laminate surface over bubbles)	Max 1/4 in., dia x 1/8 in. high, max 1 per sq ft, min 2 in apart
Wrinkles and solid blisters	Max deviation, 20% of wall thickness but not exceeding 1/8 in.
Pits(craters in the laminate surface)	Max dimensions, 1/8 in dia x 1/16 in deep, max density 10 per sq. ft.
Surface porosity(pin-holes or pores in the laminate)	Max dimensions, 1/16 in dia x 1/16 in deep, max density 10 per sq. ft.
Chips	Max dimension of break, 1/4 in, and thickness no greater than 20 percent of wall thickness, max density 1 per sq ft
Dry spot(nonwetted reinforcing)	Max dimension, 2 sq in. per sq ft
Entrapped air (bubbles or voids in the laminate)	1/8 in. max dia, 4 per sq in. max density; 1/16 in. max dia. 10 per sq in. max density

ALLOWABLE DEFECTS

<u>Defect</u>	<u>Surface inspected</u>
Exposed Glass	None
Burned Areas	None
Exposure of cut edges	None
Scratches	Max length 1 in. max depth 0.010 in.
Foreign Matter	1/16 in.dia, max density 1 per sq ft

FIBERGLASS CHOPPED STRAND MAT

1.0 Scope

1.1 The scope of these procedures is to describe the visual, physical and mechanical parameters which characterize fiberglass chopped strand mat used by the fabricator.

2.0 Definitions

2.1 Chopped Strand Mat - Chopped strand mat is made from randomly oriented glass strands which are held together in mat form using a binder. Each strand contains a sizing.

3.0 Requirements

3.1 Visual Requirements - Each roll of chopped strand mat shall be inspected to insure it is consistent in color, texture and appearance. It shall be free from surface irregularities, fluffy masses, dirt spots or other foreign material; water spots, knots, binder spots larger than 2" in diameter, clumps of strands and tears or holes which may result from removal of defects.

3.2 Physical Requirements

3.2.1 Weight - The square foot weight of the mat shall be measured for each carton of mat used. All specimens shall fall within the range specified for the product.

3.3 Packaging Requirement - Packaging shall be visually inspected to assure proper labeling and that the package is free from damage that may render the mat unusable.

3.3.1 The mat shall be packaged in an unbroken carton as shipped from the mat manufacturer's factory. The mat used shall not be repackaged in the distribution of the mat after the manufacturer has shipped the mat.

FIBERGLASS CHOPPED STRAND MAT

3.4 Documentation - It is the responsibility of the fabricator to maintain records showing the results of all material testing. This information shall show at a minimum, the following:

- (a) Form of material
- (b) Manufacturer
- (c) Manufacturer's product description including binder type (treatment)
- (d) Manufacturer's product code
- (e) Production date, if available, or production code on carton.
- (f) Property measured and value recorded
 - * Visual inspection
 - * Width
 - * Thickness
 - * Packaging
- (g) Job number (Internal Fabricator Control Number)
- (h) Fabricated part identification number